BÖHLER CN 13/4-IG

Solid wire, high-alloyed, stainless

Classifications

EN ISO 14343-A	EN ISO 14343-B	AWS A5.9
G 13 4	SS(410NiMo)	ER410NiMo (mod.)

Characteristics and typical fields of application

GMAW solid wire of low-carbon type 13% Cr 4% Ni suited for soft-martensitic steels like 1.4313 / CA 6 NM. Designed with precisely tuned alloying composition creating a weld deposit featuring very good ductility, CVN toughness and crack resistance despite its high strength. For applications like hydro- and steam turbines, corrosion resistant against water and steam.

Base materials

1.4317 GX4CrNi13-4, 1.4313 X3CrNiMo13-4, 1.4407 GX5CrNiMo13-4, 1.4414 GX4CrNiMo13-4
ACI Gr. CA 6 NM

Typical analysis of solid wire (wt.-%)

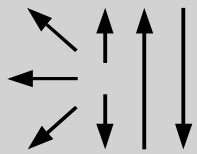
	C	Si	Mn	Cr	Ni	Mo
wt.-%	0.01	0.65	0.7	12.2	4.8	0.5

Mechanical properties of all-weld metal

Condition	Yield strength $R_{p0,2}$	Tensile strength R_m	Elongation A (L_0=5d_0)	Impact work ISO-V KV J	
	MPa	MPa	%	+20°C	-20°C
u	**950**	**1210**	**12**	**36**	
a	**760** (≥ 500)	**890** (≥ 750)	**17** (≥ 15)	**80**	≥ 47

u untreated, as welded – shielding gas Ar + 8 – 10% CO_2
a annealed, 580°C/8 h / furnace down to 300°C / air – shielding gas Ar + 8 – 10% CO_2

Operating data



Polarity:	Shielding gases:	ø (mm)
DC (+)	Argon + 8 – 10% CO_2	1.2

Preheating and interpass temperatures in case of thick-walled sections 100 – 160°C.
Maximum heat input 15 kJ / cm. Tempered at 580 – 620°C.

Approvals

SEPROZ, CE